Work Order ID 125717

125717

Tuesday, October 21, 2014 12:38:15 PM

Item ID: D4942-7 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Protector, LH

Start Date: 10/21/2014 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 10/21/2014 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MC5 **Date:** 141021 **Tooling:** **Date:** **Stop** *NR2*

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4942	D								
100		0.00							DAS 23 9-89
100	FLOW WATER JET					2	0		14-10-27
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	*****VERIFY TEXTURED SIDE BEFORE CUTTING***** 1- Cut as per Dwg Dwg Rev: D Prog Rev: D								
.125" Grey Lexan.									
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89
110						2	0		14-10-27
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
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Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				2			DAS 38 OCT 30 2014
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location P/C	0.00				2			DAS 06 OCT 30 2014
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14/10/30 DJ

MF 14-10-30

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

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Work Order: _____

Part No. _____

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Scrap ☐
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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
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Transport	☐									
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Picklist Print

Tuesday, October 21, 2014 12:38:21 PM

Work Order ID: 125717 *125717*

Parent Item: D4942-7 *D4942-7*

Parent Item Name: Protector, LH

Start Date: 10/21/2014 **Required Date:** 10/21/2014

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A 14.02.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	5,518.686	**	9			DAS 23 9-89

MLEXS.125-F60029-04

GE PLASTICS LEXAN SHEET

14-10-27

Location		Loc Qty	Loc Code	
MAT019		2958.68678		
	124866	106		
	m126425	160.925		
	m127934	665		
	m128746	336.17		
	m129759	1690.59178		128746
SABIC		2560		
	m130209	2560		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

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Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD		Work Order:	125717
Description:	Floor Protector LH	Part Number:	D4942-7
Inspection Dwg:	D4942 Rev: D		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.2"	+/-0.005"	1.2"	–		V	Jkm01
9.3"	"	9.3"	–		V	Jkm08
26.2"	"	26.2"	–		T	Jkm07
27.9"	"	27.9"	–		T	
29.5"	"	29.5"	–		T	
31.2"	"	31.2"	–		T	
32.3"	"	32.3"	–		T	
3.8"	"	3.8"	–		T	
5.0"	"	5.0"	–		V	
14.1"	"	14.1"	–		T	
14.4"	"	14.4"	–		T	
14.7"	"	14.7"	–		T	
15.0"	"	15.0"	–		T	
17.3"	"	17.3"	–		T	
0.125"	+/-0.010"	0.125"	–		V	
Ø 0.63"	+0.008"-0.001"	0.633"	–		V	
				DAS 38 9-89		

Measured by:	DAS 23 9-89	Checked by:	OCT 2 8 2014	QC Inspector:	
Date:	14.10.27	Date:		Date:	

Engineering Approval: (If necessary)		Date:	

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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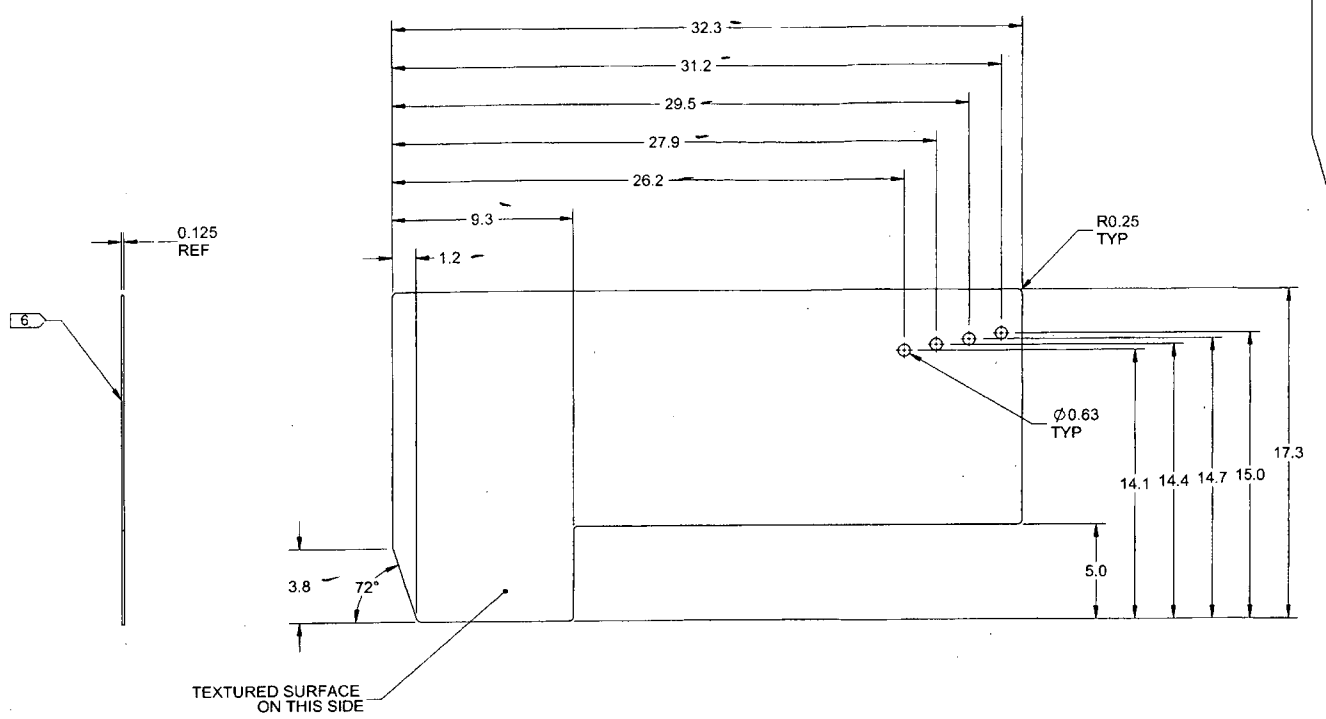
FAULT CATEGORY

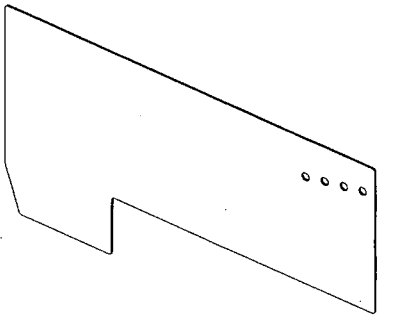
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- ☐ Other _____





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125717 MLS
14-1021

RELEASED
2014 -10- 08

D4942-7 LH PROTECTOR

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.4
7) WEIGHT: 2.3 lbs
8) CUT PER D4942-7.DXF

APPROVED

DESIGN	AK	DART AEROSPACE LTD
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA
CHECKED	VS	DRAWING NO. D4942 REV. D
MFG. APPR.	DL	SHEET 4 OF 5
APPROVED	HS	TITLE BAGGAGE PROTECTORS SCALE NTS
DE APPR.	DS	
DATE	14.06.16	

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